

Work Order ID 76802***76802***

Page 1

Monday, November 21, 2011 11:23:35 AM

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: Date: 11-21Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB071FOLIO REV: AADWG REV: E

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

B.A 11/12/13

B.A 11/12/13

8

φ

8

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76802

76802

Page 2

Monday, November 21, 2011 11:23:35 AM

Item ID: D2661-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 11/21/2011 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	11/12/13		8	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	229	11-12-14		8	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	8x0 m/l 11/12/14						

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

11/12/21

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Picklist Print

Monday, November 21, 2011 11:23:42 AM

Page 1

Work Order ID: 76802

76802

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			

D6101-003

Saddle Billet, 7075

SL 11-12-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
74680	26	

5

3

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 76802
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.122	0.122	0.125		
B	0.100	0.140		0.120	0.121	0.120	0.122		
C	1.125	1.145		1.135	1.135	1.136	1.139		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.248	0.248	0.248	0.248		
F	1.313	1.343		1.323	1.323	1.323	1.322		
G	0.210	0.230		0.220	0.220	0.218	0.221		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.576	1.576	1.578		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.109	0.109	0.109	0.109		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.800	0.798	0.799	0.798		
W	0.540	0.560		0.551	0.551	0.551	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.920	0.922	0.921	0.922		
AA	0.490	0.510		0.499	0.499	0.499	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	HA
Date:	11/12/13

Audited by:	RF
Date:	11-12-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	NA

W/O:		WORK ORDER CHANGES					
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Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		0.126	0.128	0.125	0.130		
B	0.100	0.140		0.123	0.123	0.125	0.123		
C	1.125	1.145		1.135	1.133	1.134	1.134		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.250	0.250	0.249	0.251		
F	1.313	1.343		1.324	1.324	1.324	1.324		
G	0.210	0.230		0.223	0.222	0.224	0.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.573	1.574	1.574		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.109	0.109	0.109	0.109		
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N	0.510	0.515		0.512	0.512	0.512	0.512		
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Z	0.912	0.932		0.922	0.922	0.921	0.922		
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AF									
Accept/Reject									

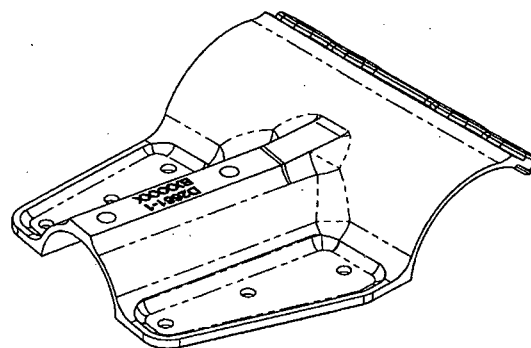
Measured by: B.A.
Date: 11/12/13

Audited by: T.R.
Date: 11.12.14

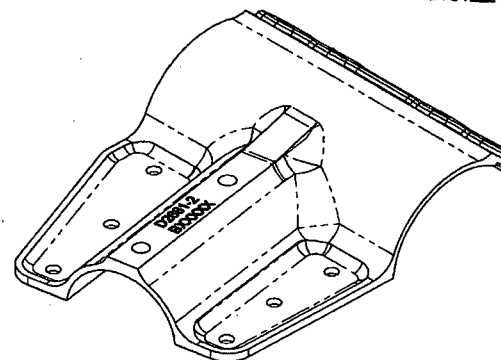
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76802

211-112



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE																												
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B6-4), REF NCR 11-935	CP	11.10.31																												
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08																												
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29																												
B	ANGLE AND NOTES ADDED	KE	07.07.11																												
A	NEW ISSUE	DS	07.03.25																												
<table border="1"> <tr> <td>DESIGN</td> <td><i>Q</i></td> <td colspan="2">DART AEROSPACE USA, INC.</td> </tr> <tr> <td>DRAWN</td> <td><i>Q</i></td> <td colspan="2">KENT, WA</td> </tr> <tr> <td>CHECKED</td> <td><i>AS</i></td> <td>DRAWING NO.</td> <td>REV. E</td> </tr> <tr> <td>MFG. APPR.</td> <td><i>MA</i></td> <td>D2661</td> <td>SHEET 1 OF 5</td> </tr> <tr> <td>APPROVED</td> <td><i>MA</i></td> <td>TITLE</td> <td>SCALE</td> </tr> <tr> <td>DE APPR.</td> <td><i>MA</i></td> <td>SADDLE, OUTSIDE</td> <td>NTS</td> </tr> <tr> <td>DATE</td> <td>11.10.31</td> <td colspan="2"> <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> </td> </tr> </table>				DESIGN	<i>Q</i>	DART AEROSPACE USA, INC.		DRAWN	<i>Q</i>	KENT, WA		CHECKED	<i>AS</i>	DRAWING NO.	REV. E	MFG. APPR.	<i>MA</i>	D2661	SHEET 1 OF 5	APPROVED	<i>MA</i>	TITLE	SCALE	DE APPR.	<i>MA</i>	SADDLE, OUTSIDE	NTS	DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
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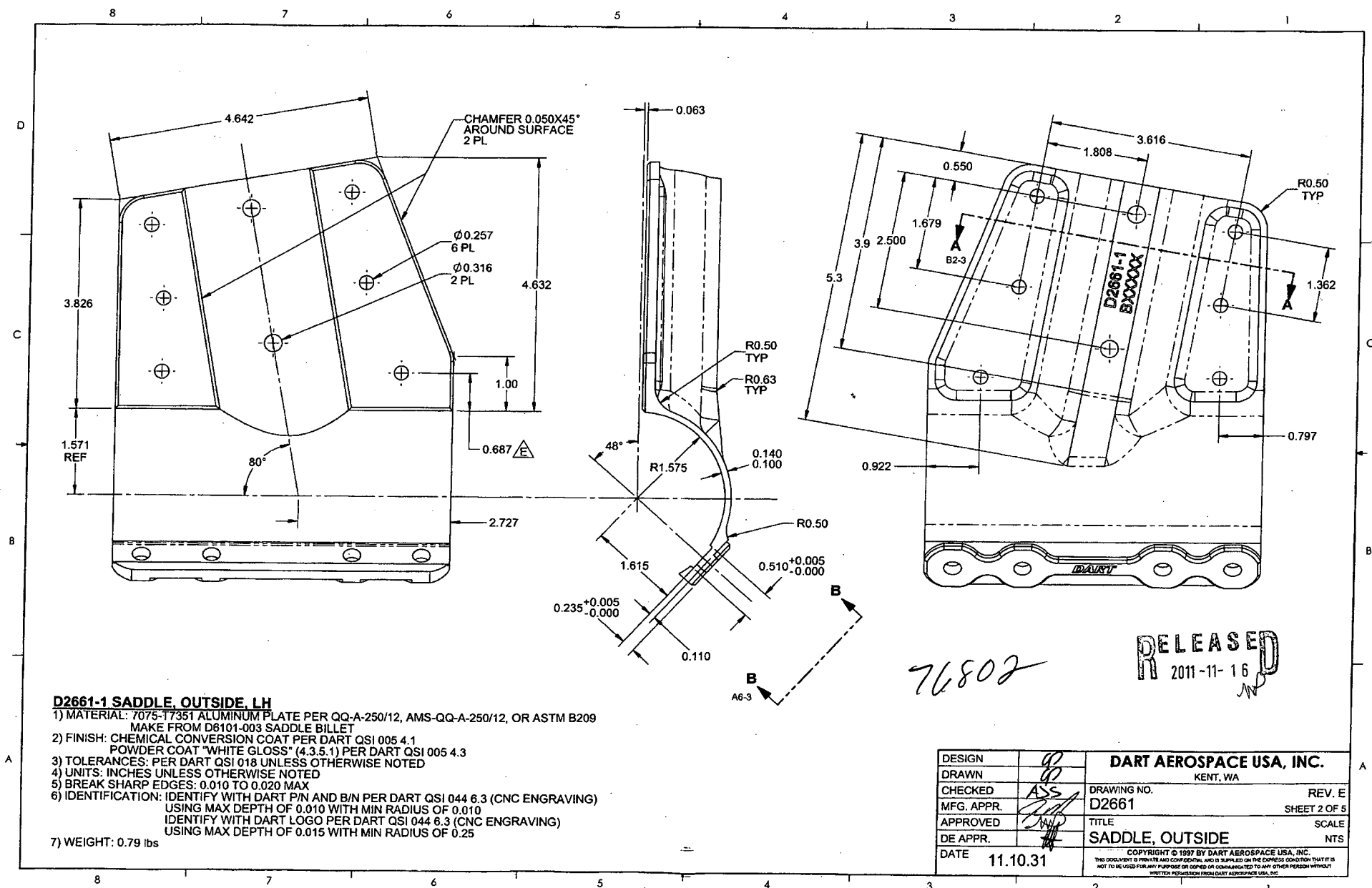
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	76802	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	SW	D2661	SHEET 2 OF 5
APPROVED	SW	TITLE	SCALE
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RELEASED
2011-11-16

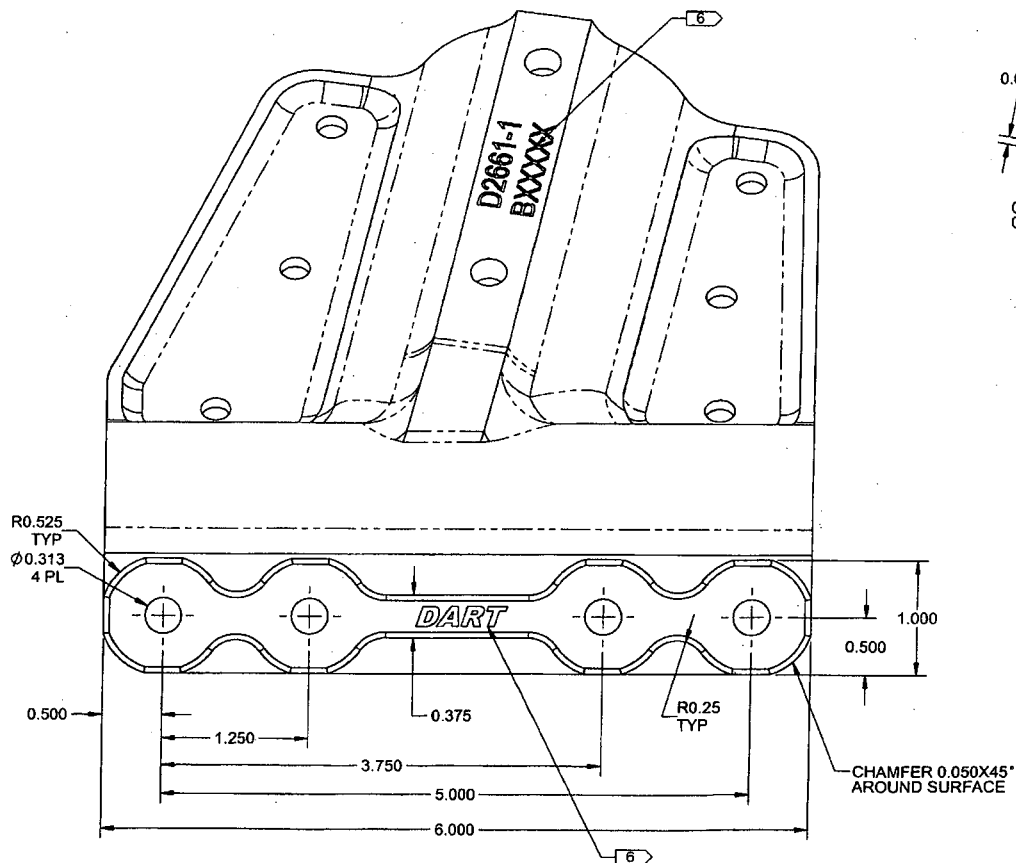
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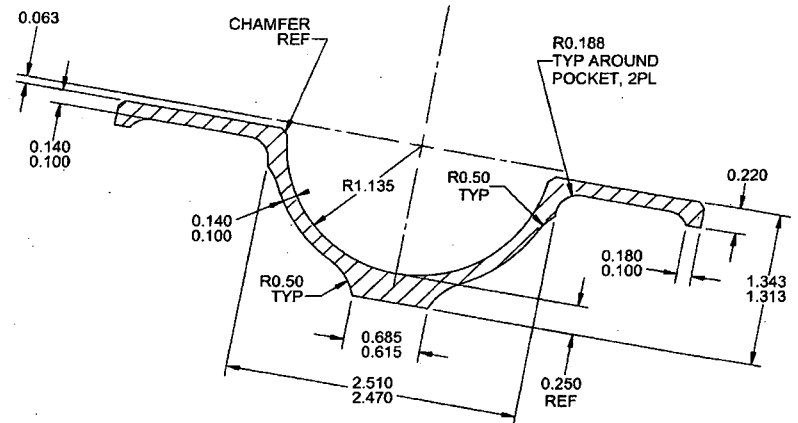
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VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C3-2

76802

RELEASED
R 2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED	SS	DRAWING NO.	REV. E
MFG. APPR.	JAN	D2661	SHEET 3 OF 5
APPROVED	JAN	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
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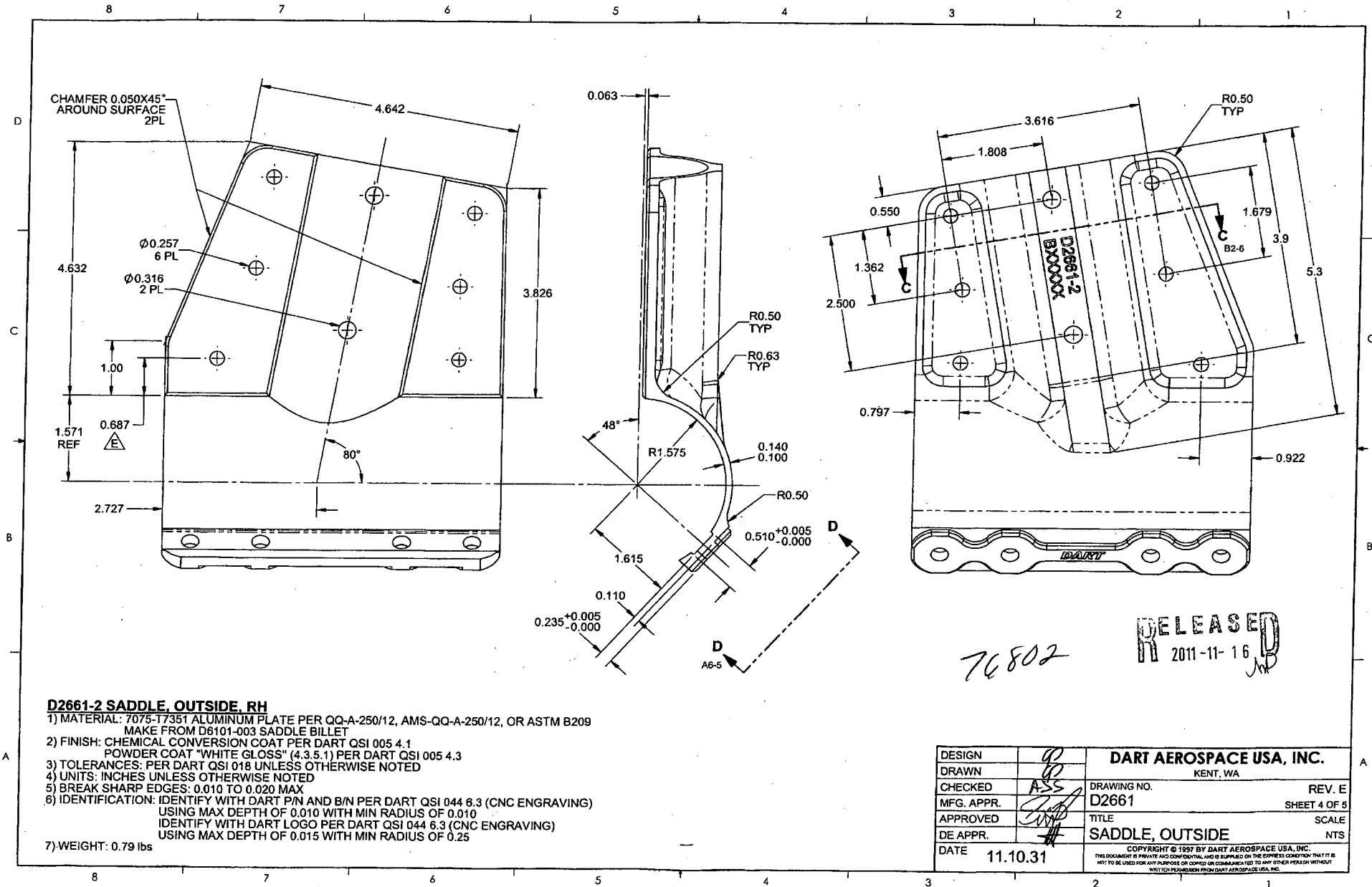
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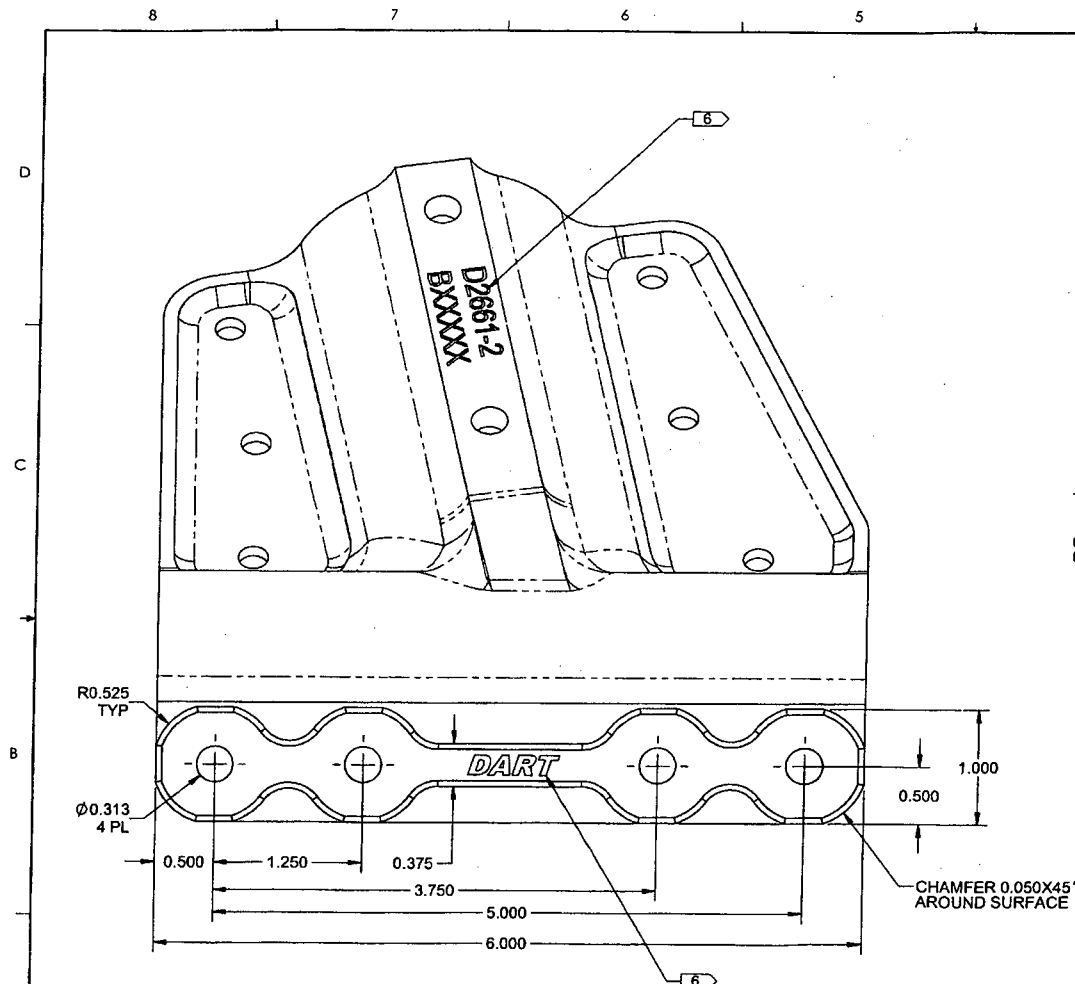
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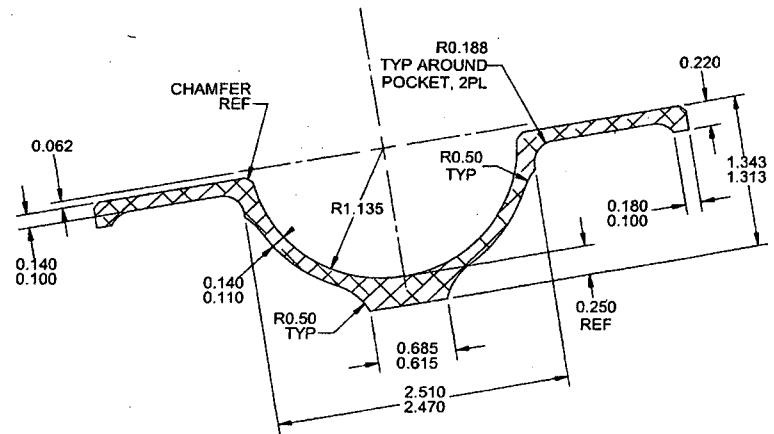
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VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

76802

RELEASED
2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	90	D2661	SHEET 5 OF 5
APPROVED	90	TITLE	SCALE
DE APPR.	90	SADDLE, OUTSIDE	NTS
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